

5/23

DART AEROSPACE LTD	Work Order:	23250
Description: Saddle billet	Part Number:	D6101-007
Drawing: D6101 Rev. A	Qty:	50

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Open W/O	KL	05.05.11	50
2	PURCHASING	Issue P/O: <u>200635</u> a) Description: Alluminum billet b) 7.750" x 8.250" x 2.50" thick c) Tolerance on all dimensions are +0.030"/-0.000" d) Grain direction along 7.750" length e) Material: 7075-T7351 (QQ-A-250/12) Material certification required	N	05.05.12	50
3	RECEIVING	Receive & Inspect for transit damage Ensure certification are attached	CL	05/06/10	50
4	QC	Inspect level 6 Check certification to Dwg D6101 for compliance	EC	05/06/10	50
5	STORES	Identify & stock	EC	05/06/13	50
6	EXPEDITING	Close W/O <u>105.12</u> Cost / part <u>109.44</u> <u>05.06.15</u> Inspect Level 21	AR	05/06/14	50

Rev	Date	Change	Revised By	Approved
A	01.05.04	New Issue	EC	EC

RELEASED

EC 01.05.16

KF
03.06.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

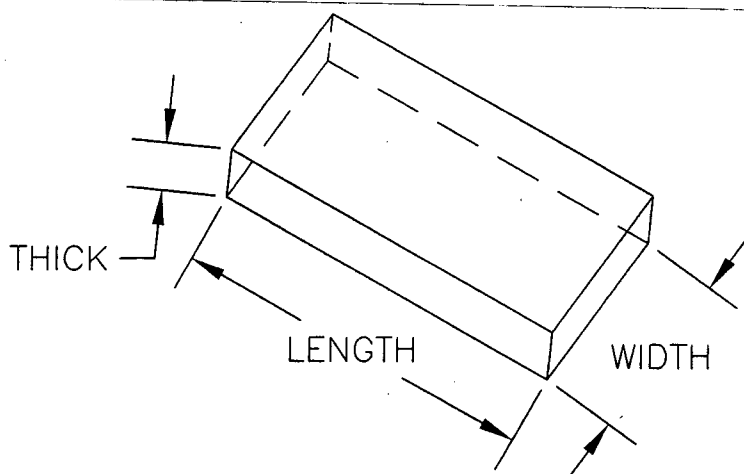
QA: N/C Closed: _____ Date: _____



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>AS</i>	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 *#*



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.100 Length

ON-OF COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY

IT IS A MODIFICATION

THAT NOTICE

WORK ORDER

23250

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 09, 2005
02:16 pm

Work Order No	: 0023250	Department Code:	
Project Name	: D6101-007	Burden Flags	: NNNNNNNN
Project For	: WK523	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D6101-007	Invoice Number	:
Description	: 7075-T7351 8.25X7.75X2.5	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 50	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 05-09-05		
Est Finish Date	: 06-10-05	Est Mark Up	: 0.000%
Act Finish Date	:	Actual Mark Up	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
=====					
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====					
Burden	: 0.00	0.00	0.00		
=====					
Total Cost	: 0.00	0.00	0.00		
Mark up	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

Ship From: RIVERDALE, IA.

Chemical Composition											
	SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
Max	.40	.50	2.0	.30	2.9	.28	6.1	.20	.05	.15	
Min			1.2		2.1	.18	5.1				REMAIN

RTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS
Ship From: RIVERDALE, IA.

I hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Mark J. Vrabec

Mark J. Vrabec
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

391309

Ship Date

2005-04-09

P.O. No./Govt Contract No.

CA9719

99012

B.L. No.

73528

Invoice No.

06069

Customer

C&B-WALLINGFORD

Alcoa No. Item

DS-83315-1

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Lot: 769271 -Mechanical, Physical, Metallography, Quantometer Results -----

Temp	Dir	No.	UTS	TYS	EL4D
		Test	KSI	KSI	PCT
T7351	Long Transv.	3	Max 71.5	60.7	10.3
			Min 71.2	60	10.1
T7351	Elect Cond	%IACS	40.7	40.8	40.8 PCT

Cast Number	Chemical	SI	FE	CU	MN	MG	CR	ZN	TI
H4051106	Actuals	.07	.27	1.6	.03	2.5	.19	5.8	.02

Lot: 769272 -Mechanical, Physical, Metallography, Quantometer Results -----

Temp	Dir	No.	UTS	TYS	EL4D
		Test	KSI	KSI	PCT
T7351	Long Transv.	3	Max 70.9	60.1	10.6
			Min 70.6	59.5	9.8
T7351	Elect Cond	%IACS	40.7	41.1	40.8 PCT

Cast Number	Chemical	SI	FE	CU	MN	MG	CR	ZN	TI
H4051106	Actuals	.07	.27	1.6	.03	2.5	.19	5.8	.02

